

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024787**Date Inspected:** 21-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Shi Yu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC perform FCAW welding on lifting lug and grinding work on the hand rail and lifting lug,

Bay 9

Heat straightening of PCMK, BKSA011, under approved Heat Straightening procedure, HSR 1 (B)-10403, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Chen Shi Gang. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 10mm.

ZPMC perform fit up and grind work on bike path,

Bay 13

This QA Inspector observed the following work in progress for Bay 13.

ZPMC perform grinding work on the Architectural housing,

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

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ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Splice Angle

PCMK: DP3126A-7407H

Welder: 020387

WPS-B-T-2231-ESAB

ZPMC performed SMAW tack welding, VT repair welding and grind work on splice angle

Bay 16

This QA Inspector observed the following work in progress for Bay 16

ZPMC performed SMAW tack welding on hand rail and VT repair welding on Steel Barrier.

Also grind work, pre assembly work on steel barrier.

Bay 19

This QA Inspector observed the following work in progress for Bay 19

ZPMC performed grind work on BK 25A and BK 23A.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
